Qty:

Date:

Tuesday, 4/25/2006 7:35:08 AM

User:

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

: LUG

: D2657

: N/A

: NIA

: 5/10/2006

: A

D2657 REV A

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 26786A

: 10338

P.O. Number

MM.

This Issue Prsht Rev.

Previous Run

Written By

: 4/25/2006 : NC

First Issue

: NIA : 21713A

S.O. No. : NIA

: PURCHASED PARTS

Checked & Approved By Comment

: Est Rev: A

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

M1010B0750X02500 1.0

ASTM A21 Steel .75"x2.5"

Comment: Qty.:

0.1925 f(s)/Unit Total: 5.7740 f(s) Material: ASTM A36 steel bar 2.50" x 0.75" thick

(M1010-B0.750 x 02.500)

Batch M 100283

06/05/05

30 Um:

Each

2.0

BAND SAW



BAND SAW

Comment: BAND SAW

Cut blanks: 2.200" long

HAAS CNC VERTICAL MACHINING #1

3.0

HAAS1





Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio FA040 and Dwg D2657

2-Deburr

06/05/05

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

06/05/05

30

Dart Aerospace Ltd

W/O:		WORK ORDER CH	IANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			,	:				
Part No		PAR #: Fault Category:	NC	R: Yes	No DQA	:S	Date: Ò	6/05/09
					N/C Closed			

NCR:		V	WORK ORD	ER NON-CONFO	RMANCE	(NCR)			
		Description of NC	Corrective Action		Section B		Verification	A	
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
					}				
								i	
							,		

NOTE: Date & initial all entries

Tuesday, 4/25/2006 7:35:08 AM Date: User: Kim Johnston **Process Sheet Drawing Name:** LUG Customer: CU-DAR001 Dart Helicopters Services Job Number: 26786A Part Number: D2657 Job Number: **Description:** Seq. #: **Machine Or Operation:** PACKAGING RESOURCE #1 PACKAGING 1 6.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: DOCUMENT CONTROL 7.0 DC U 06-U5-28 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Ae	rospace	e Lta								
W/O:			WC	RK ORDER CH	ANGES			•		
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Dord No.		DAD #								
Part No	:	PAR #:	Fault Cate	Jory:	NC				Date: _ _ Date: _	
NCR:		V	VORK ORDI	ER NON-CONFO	RMANC	E (NCR	4)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B	Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector
				,	1					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26786A
Description: Lug	Part Number:	D2657
Inspection Dwg: D2657 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		X First Arti	icle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/-0.010	378	/			
1.20	+/-0.030	1.205				
0.060	+/-0.010	-070				
R1.68	+/-0.010	5.1.68				
0.510	+/-0.010	2/0	//			
R0.65	+/-0.030	1.654				
1.92	+/-0.030	1.930				
				-		
4., 459						

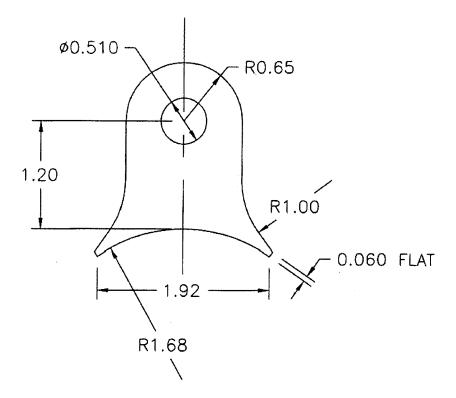
Measured by: J.L	Audited by:	Sp	Prototype Approval:	N/A
Date: 06/05/05	Date:	oblasta	Dàte:	

Rev	Date	Change	Revised by	
Α	03.12.23	New Issue	KJ/RF	· +





	C DCC(O)	Iopanai pv	·		
	DESIGN	ORAWN BY	I DART AER	OSPACE LTD	
	קאיש	VINO		ONAL AIRPORT, CANADA	
	CHECHOOD	APPROVED	DRAWING NO.		REV. A
		A	D2657	SHEET	1 OF 1
	DATE		TITLE	•	SCALE
	97.11.03	3.8	LUG		1:1
_	Α	97.11.03	NEW ISSUE		



0.063

BREAK ALL SHARP CORNERS 0.010 TO 0.020 MATERIAL: ASTM A36 STEEL 0.375 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWINDSED PART IS SYMMETRIC AROUT CENTER LINE PART IS SYMMETRIC ABOUT CENTER-LINE

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SUBJECT TO AMENDMENT WITHOUT NOTICE